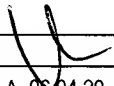
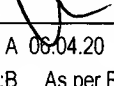


Date: Tuesday, 18/09/2007 11:13:43 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE
Job Number : 34695	
Estimate Number : 12303	
P.O. Number : N/A	Part Number : D34673
This Issue : 18/09/2007 S.O. No. : N/A	Drawing Number : D3467 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 34099	Material : N/A
Written By : 	Due Date : 25/09/2007 Qty: 10 Um: Each
Checked & Approved By : 	
Comment : est rev. A 06-04-20 new issue EC Est Rev:B As per Rev B 06-05-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.1985 sf(s)/Unit Total : 1.9845 sf(s)
304/316 0.018 SHEET batch: 105591 LB 07-09-18

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
Cut as per Dwg D3467 LB 07-09-18
Dwg Rev: B
Prog Rev: B

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE LB 07-09-18

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

En 12/09/18 410 counted

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Roll as per dwg D3467
2- Spot weld as per dwg D3467 & QSI004
3-Form bead as per dwg D3467

mf 07-09-19 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: PD Date: 07/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 18/09/2007 11:13:43 AM

User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 34695

Part Number: D34673

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/09/19 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-09-19 (10)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/19

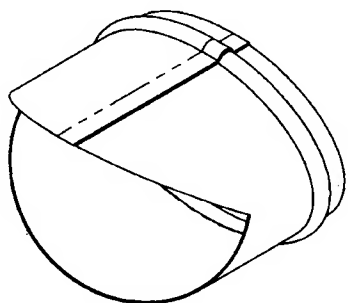
Job Completion



07/09/19



DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3467	REV. B SHEET 7 OF 15
DATE 06.05.15		TITLE SHROUD ASSEMBLY	SCALE 1:2

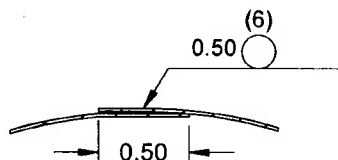


RELEASED
06.05.15

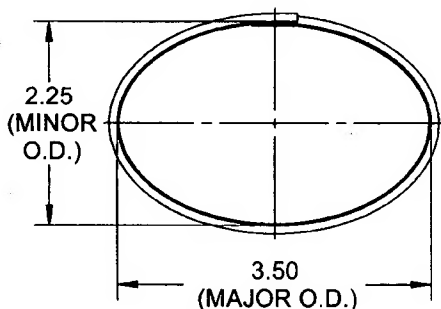
UNDER REVIEW

02.09.15

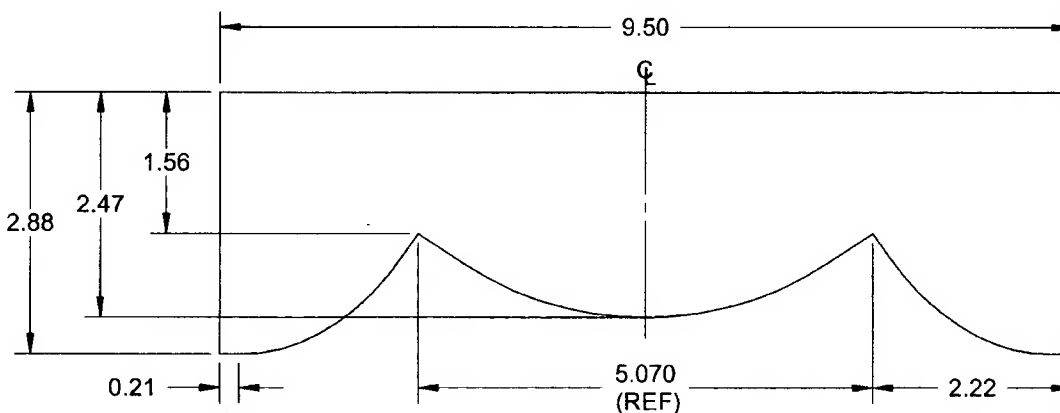
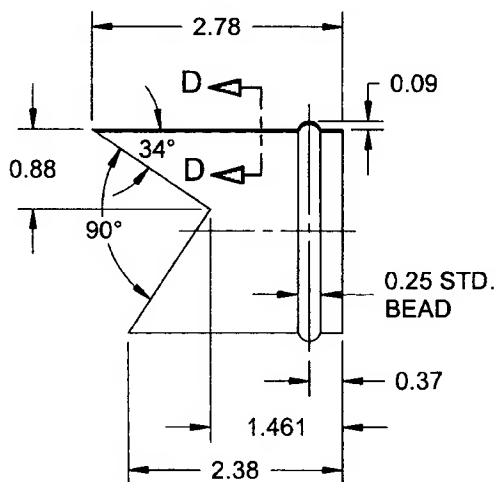
*Dist. + Manufacturing
(Chait)*



SECTION D-D
SCALE 1:1



D3467-3 TUBE DETAIL



D3467-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) SPOT WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

W/0 34695

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 16

EMPLOYEE: Melanie Fantoni

PART NUMBER: D3467-3

JOB NUMBER: 34695

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.18

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☐

Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>✓</u>]	[]
PENETRATION:	[<u>✓</u>]	[]
FULL STRENGTH:	[<u><</u>]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/09/19

QUALIFIER: SA

